



Dart Aerospace Ltd.
1270 Aberdeen St
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RB23003267
Job Sheet 197213



Part No: RB23003267

Job Qty: 4 pcs

Part Name: Power Turbine Support Cleaning C-18, C-20 & C-28



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Due Date: 10/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB23003267 Rev.E IPP Rev. A 19.02.13 New issue DP Verify DD/IPP Rev. B 19.08.09 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Small Fab - Issue SN	4 pcs	10/10/19	10/10/19	0.00	0.00	Small Fab - 2		MH
100	Small Fab - 1	4 pcs	10/10/19	10/10/19	0.00	0.50	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 2 - B4B		MH
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	10/10/19	10/10/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	4 pcs	10/10/19	10/10/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S220785



Part: RB23003267

Job No: 197213

Serial No/Batch: S220785

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 10/08/19

DAS
OCT 08 2019 40
8-89

10/8/2019

[Dart Hawkesbury] Job Sheet - Leclair, Mathieu

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
140 QC 21 - FG	4 pcs	10/10/19	0.00 0.00	QC 21 - FG - 21	21
				QC 21 - FG - 70	9-89
				QC 21 - SA - 53	

GA ISIA

DM

Part Op 95 - Issue S/N
 Descriptions: 100 - 1-Cut RB23003267 foam. 2-Pick and pack as per drawing.
 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

OCT 11 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	4 pcs (1 ea)	95-Small Fab - Issue SN	5021040
1887T48	Oil-Resistant Buna-N Foam Sheet, 1" Thick, 40" x 68"	.8880 sf (.222 ea)	100-Small Fab - 1	5175872
K206	Flambeau Plastic Box (Clean Out)	4 Ea (1 ea)	100-Small Fab - 1	5127655
RB23003267-1	Clean Guide	4 pcs (1 ea)	100-Small Fab - 1	5214691
RB23003267-11	#12 Drill Bit & Block Assembly	4 pcs (1 ea)	100-Small Fab - 1	5199645
RB23003267-13	Hack Saw Blade-6"	4 pcs (1 ea)	100-Small Fab - 1	5214346
RB23003267-3	#56 Drill Bit & Block Assembly	4 pcs (1 ea)	100-Small Fab - 1	5199655
RB23003267-5	#52 Drill Bit & Block Assembly	4 pcs (1 ea)	100-Small Fab - 1	5199662
RB23003267-7	#27 Drill Bit	4 pcs (1 ea)	100-Small Fab - 1	5199676
RB23003267-9	#22 Drill Bit & Block Assembly	4 pcs (1 ea)	100-Small Fab - 1	5199663
8860K15	Bend-and-Stay 304 Stainless Steel Wire, Matte Finish, 1/4-lb. Spool, 0.041" Diameter	13.6800 Ea (3.42 ea)	100-Small Fab - 1	5206432

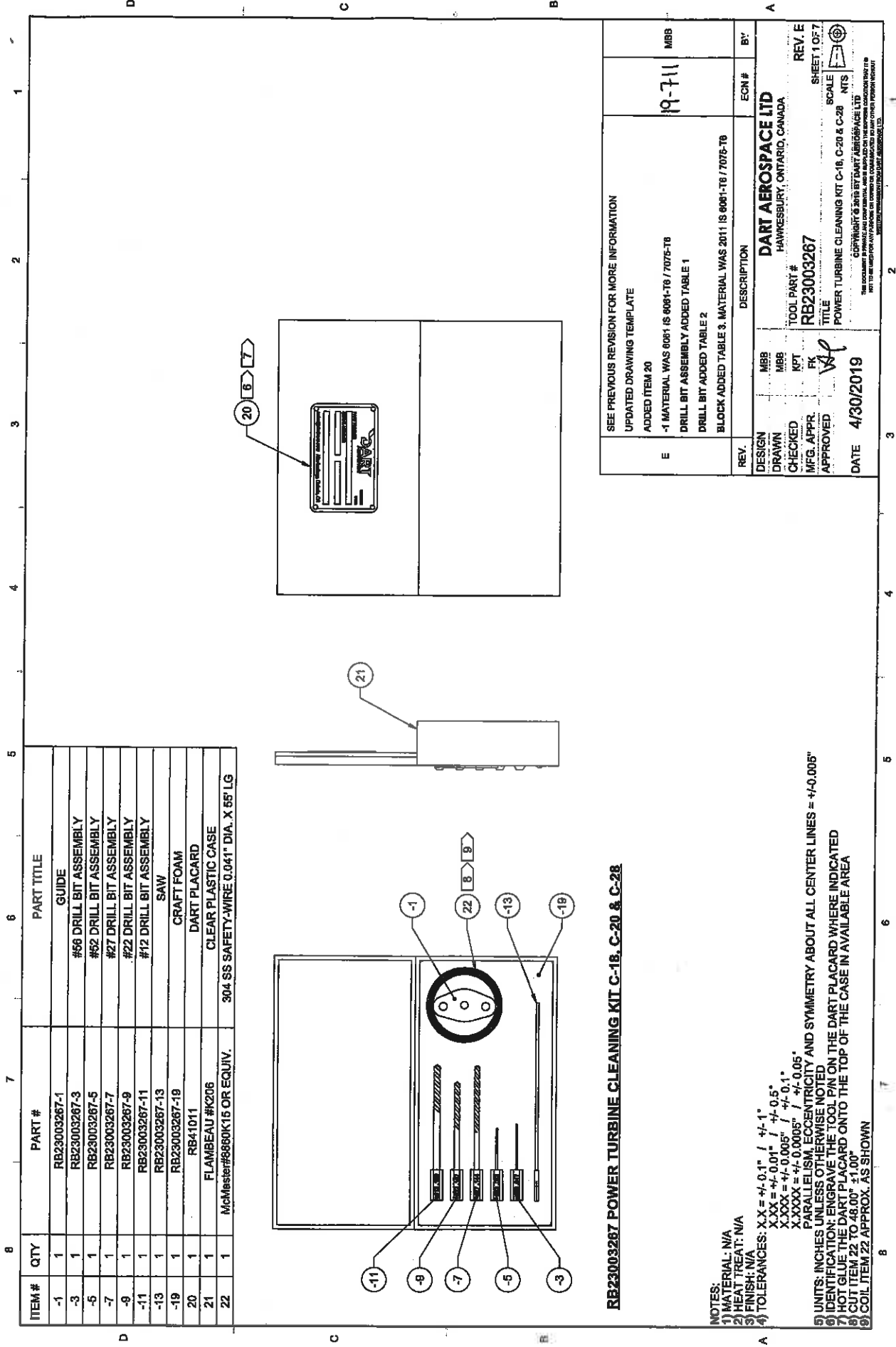
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Small Fab - Issue SN	RB41011	4	200	0
100-Small Fab - 1	1887T48	1	13	0
	8860K15	14	14	0
	K206	4	56	0
	RB23003267-1	4	7	0
	RB23003267-11	4	4	0
	RB23003267-13	4	12	0
	RB23003267-3	4	4	0
	RB23003267-5	4	4	0
	RB23003267-7	4	4	0
	RB23003267-9	4	4	0

Part Specifications

Specifications could not be found.

Plex 10/8/19 9:13 AM dart.leclair.mathieu



ITEM #	QTY	PART #	PART TITLE
-1	1	RB23003267-1	GUIDE
-3	1	RB23003267-3	#66 DRILL BIT ASSEMBLY
-5	1	RB23003267-5	#52 DRILL BIT ASSEMBLY
-7	1	RB23003267-7	#27 DRILL BIT ASSEMBLY
-9	1	RB23003267-9	#22 DRILL BIT ASSEMBLY
-11	1	RB23003267-11	#12 DRILL BIT ASSEMBLY
-13	1	RB23003267-13	SAW
-19	1	RB23003267-19	CRAFT FOAM
20	1	RB41011	DART PLACARD
21	1	FLAMBEAU #K206	CLEAR PLASTIC CASE
22	1	McMaster#860K15 OR EQUIV.	304 SS SAFETY-WIRE 0.041" DIA. X 65" LG

RB23003267 POWER TURBINE CLEANING KIT C-18, C-20 & C-28

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: ENGRAVE THE TOOL PIN ON THE DART PLACARD WHERE INDICATED
7) HOT GLUE THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA
8) CUT ITEM 22 TO 48.00" $\pm 1.00"$
9) COIL ITEM 22 APPROX. AS SHOWN

SEE PREVIOUS REVISION FOR MORE INFORMATION	19-711	MBB
UPDATED DRAWING TEMPLATE		
ADDED ITEM 20		
-1 MATERIAL WAS 6061 IS 6061-T8 / 7075-T8		
DRILL BIT ASSEMBLY ADDED TABLE 1		
DRILL BIT ADDED TABLE 2		
BLOCK ADDED TABLE 3. MATERIAL WAS 2011 IS 6061-T8 / 7075-T8		
REV	DESCRIPTION	BY
DESIGN	MBB	
DRAWN	MBB	
CHECKED	KPT	
MFG. APPR	PK	
APPROVED		
DATE 4/30/2019		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
TOOL PART # RB23003267		
TITLE POWER TURBINE CLEANING KIT C-18, C-20 & C-28		
SCALE N/A		
SHEET 1 OF 7		
REV. E		
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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet ☐ Supplier Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				Completed By Lead hand / Supervisor QC / QA Coordinator			